

Work Order ID 62222

Wednesday, September 22, 2010 3:14:09 PM



Page 1

Item ID: D2278

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Leg

Start Date: 9/22/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: PLDate: 10-9-22

Tooling:

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2278

Rev F

100

0.00



FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D2278 ☐ Dwg Rev: F ☐ Prog Rev: F ☐ 2-
Deburr if necessary10-9-28

(10)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

10-9-28

120

0.00



QC8- Inspect parts - second check

0.00

QC

Memo

Quality Control

10/6/20(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

10-9-29

Memo

0.00

10

0

Hand Finishing

140



QC

QC3- Inspect Part Finish

0.00

10/19/29

Memo

0.00

10

0

Quality Control

150



Packaging

Identify as per dwg & Stock Location: _____

0.00

SYLVIA

Memo

0.00

Packaging

10/19/25 (10)

W/O:		WORK ORDER CHANGES					
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Required Date: 9/29/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/30

MK 10-9-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, September 22, 2010 3:14:14 PM

Page 1

Work Order ID: 62222



Parent Item: D2278



Parent Item Name: Step Leg

Start Date: 9/22/2010

Required Date: 9/29/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 05-11-07 JLM
 IPP Rev:B Now 6061-T6 06-06-23 JLM
 IPP Rev C New flat pattern 08.01.11 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.080		Purchased	No			100	sf	106.0512	0.9815	8.265263	9.9		
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6061-T6 .080 Sheet

1810-9-28

Location

Loc Qty

Loc Code

MAT

106

115689

106

115689

MAT21

0.0512

113438

0.0512

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE LTD		Work Order:	62222
Description: Leg		Part Number:	D2278
Inspection Dwg: D2278 Rev: F		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.354	+/-0.010	354	✓		V RB02	
0.354	+/-0.010	355	✓		V	
16.46	+/-0.030	16.46	✓		T	
Ø0.128	+0.005/-0.000	.132	✓		✓	
R0.354	+/-0.030	354	✓		V	
2.00	+/-0.030	1.996	✓		V	
4.74	+/-0.030	4.743	✓		V	
8.46	+/-0.030	8.477	✓		V	
0.213	+/-0.010	.215	✓		V	
0.750	+/-0.010	.752	✓			
0.080 thick	+/-0.010	.078	✓		V	

Measured by:	R	Audited by:	S	Prototype Approval:	N/A
Date:	10-9-28	Date:	10/9/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	
B	06.03.08	Dwg Rev. changed	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	
D	08.02.28	Dimensions updated per Dwg Rev F	KJ/DD	

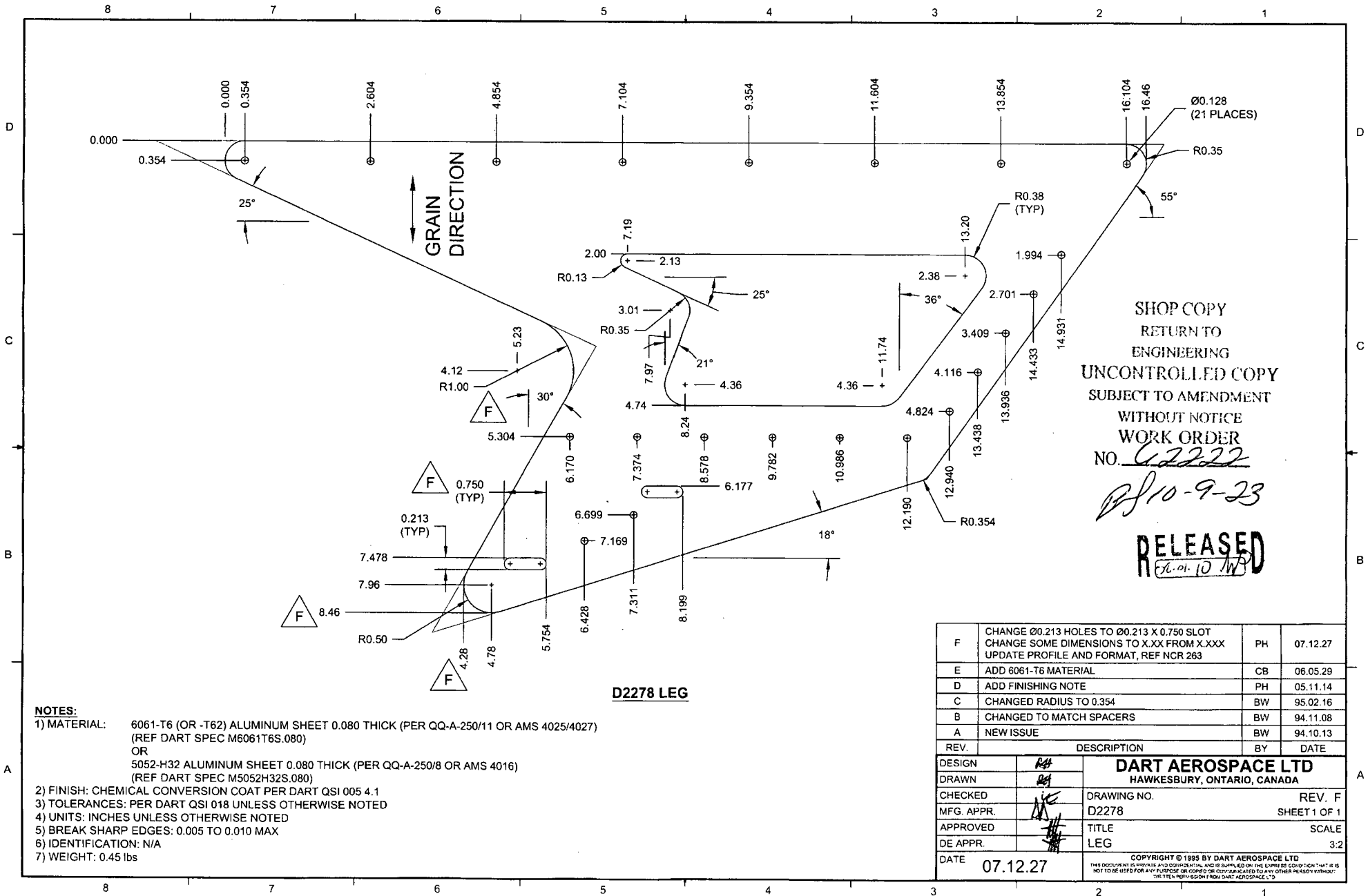
Dart Aerospace Ltd

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 62222

10-9-23

RELEASED
6.01.10 W

W/O:		WORK ORDER CHANGES					
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